	er ID 94307 mber 06, 2012 10:44:12 AM	suip	*9430	)7*	<del></del>			- 14 5 1-44		Page 1
Item ID: Revision ID:	D412-698-112		Accept	*N90004	.010c	)*	Setup	Start	*N:	S1*
Item Name:	Cabin Door Roller, RH							Stop	*N:	S2*
Start Date:	12/6/2012 Start Qty: 4.00	*4*		Cust Item ID:						
Required Date: Reference:	: 12/21/2012 Req'd Qty: 4.00	*4*		Customer:						
Approvals:	Process Plan:	Date: 12-12-0	7 Tooling:	Date:			Run	Start	*N	R1*
	QC:	Date:	SPC (Y/N):	Date:				Stop	*N!	R2*
Sequence ID/ Work Center II	Operation Description		Set Up/ Run Hours	Tool ID Too	l# Plan Code	Accep Qty	t Re		Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr				£ 10 1 1					
DSI 9635	A							1		
*1 \\n\*\ DC  Document Control	DOCUMENT CONT  Memo  Photocop		0.00 <b>PPP D412-698-112-CHGPQ1</b>			4	4	di	MG	712-12-1
*110	Pick Kit		0.00 RRQ			Цx	/			70
Packaging Packaging	Memo		0.00				<u> </u>		10	1-12-17
*120	QC4- 100% Inspect k	its for completeness	0.00 SAS			4				
QC Quality Control	Memo		الادا وا <sup>00.0</sup>			esta de				

		1
DQA:	Date:	
	 •	 4

NCR:	Yes	1	Nο

## **WORK ORDER NON-CONFORMANCE / UPDATE**

									QA Closed:	Date	<i>ţ</i> ::::::::::::::::::::::::::::::::::::		
Work Orde	DISPOSITION AGAINST DEPARTMENT/PROCESS												
Part N NCR N	o				Rework Scrap Use-as-is Work Order Update	4 1	Skid-tube  Machining  moforming  Large Fab	Crosstube Small Fab Finishing Composite	Prod. Eng. Coor. Qualit				
Root				Descri	ption of work order update	Initial	Ac	tion	Sign &				
Cause	Date	Step	Qty		or Non-conformance	Chief Eng	Desc	cription	Date	Verification	QC Inspector		
Doc/Data			in .					·					
Equip/Tooling													
Operator													
Material						1							
Setup													
Other													
Process													
Supplier						73							
Training						9							
Unapproved		<u> </u>											
· · · · · · · · · · · · · · · · · · ·				. <u> </u>		AULT CAT	GORY						
Landin	<del></del>			_	General	_			-	_			
-	Bending				Bend	Grain			Ovalized		Pressure/Forced		
1	Centre N	ot Concer	ntric to	O/S	BOM/Route	Hardw			Over/Under	tolerance	Temperature/Cure		
1	Cracks			<u> </u>	Broken/Damaged	<b>—</b>	tion Incomplete		Part Incorre	<u> </u>	Weld		
-	Crushed/	Crimped.		_	Burrs		tions Incomplete/	'Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled		
-	Cuffs		•	<u> </u>	Contamination	$\vdash$	enance		Part Moved				
-	Heat Trea			<u> </u>	Countersink	Mislab			Positioned V				
1	Inspectio	-	Tube		Cut Too Short	Misrea	ıd		Power Loss/	Surge	Other		
-	Ripples in			<u> </u>	Drill Holes	Offset	16						
	Torque W		xtrusio	n  _	Drawing	<del></del>	Calibration						
-	Turning S			<u> </u>	Finish	Out of Sequence							
	Wave/Tw	ist in Tub	e		Folio	Outsid	e Dimensions						

\*94307\*

Work Order ID 94307 Page 2 Thursday, December 06, 2012 10:44:12 AM Item ID: D412-698-112 Accept \*N900040100\* Setup Start **Revision ID:** Cabin Door Roller, RH Item Name: **Start Date:** 12/6/2012 Start Qty: 4.00 \*4\* **Cust Item ID: Required Date:** 12/21/2012 Req'd Qty: 4.00 **Customer:** Reference: Start Run Process Plan: **Approvals:** Date: Tooling: Date: Stop QC: Date: SPC (Y/N): Date: Sequence ID/ **Operation** Tool ID Set Up/ Tool # Plan Accept Reject Reject Insp. **Work Center ID** Description **Run Hours** Qty Code Qty Number 130 0.00 Packaging \*130\* Packaging Memo Packaging Identify and pack for shipping as per PPP D412-698-112 Location: 140 QC21- Final Inspection - Work Order Release 0.00 12/12/18 D \*140\* OC 0.00 Memo Quality Control

		DQA:	Date:	
				•
. Vac / Na	MODE ODDED MON CONFORMANCE / LIDDATE			•

NCR: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE														
4						·					QA Closed:	Dat	e:	1
Work Orde	er:					DISPOSITION AGAINST I					DEPARTMENT/PROCESS			
Part No.  NCR No.						Rework Scrap Use-as-is Work Order Update  Skid-tube Machining Machining Thermoforming Large Fab Crosstube Small Fab Thermoforming Composite			Small Fab Finishing		Water Jet d. Eng. Coor. e/Packaging Supplier		neering Quality Other	
Root		Y				ption of work order update	1	nitial		tion	Sign &			
Cause		Date	Step	Qty	•	or Non-conformance	Ch	ief Eng	Descr	ription	Date	Verification	ı QC	Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved					`			,						
							AUL	T CATE	GORY					
Landi					<b>_</b>	General	_	1			ד			
		Bending Centre No Cracks	ot Concer	ntric to	o/s	Bend BOM/Route Broken/Damaged		Grain Hardwa	ware		Ovalized Over/Under tolerance Part Incorrect			re/Forced erature/Cure
1	Н	Crushed/Crimped				Burrs		1	ion Incomplete tions Incomplete/I	Unclear	Part Lost/Mi		_	g Stock Pulled
	-	Cuffs	cimped.	-	-	Contamination	$\vdash$	4	enance	-	Part Moved	331118		, stock i uneu
	-	Heat Trea	ıt			Countersink		Mislabe			Positioned V	Vrong		
	${}^{-}$	Inspection		Tube		Cut Too Short		Misread			Power Loss/		Other	
	-	Ripples in			•	Drill Holes		Offset	·	<u> </u>	_	~ (		
				xtrusio	n	Drawing		4	Calibration					
	Torque Waves in Extrusion Turning Sequence					Finish		Out of	Sequence					

Outside Dimensions

Wave/Twist in Tube

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

## **Picklist Print**

Thursday, December 06, 2012 10:44:11 A

Work Order ID:

94307

Parent Item:

D412-698-112

Parent Item Name:

Cabin Door Roller, RH

**Start Date:** 12/6/2012

**Required Date: 12/21/2012** 

Page 1

Start Qty: 4.00

Required Qty: 4.00

Comments:	IPP REV:A 12.11.	29 NEW ISSUE	DD VE	DE:II M				5.	Qey 1		required	Qty. 4.00	
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on e Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3121-141 Bracket Assembly		Manufactured	No .				Each	16.0000	3	12	3 8	٥, ·	
Sm 4	<b>X</b>			Location		Loc Qty	Ţ	oc Code			0,		• \
<i>Q</i> .,				ST235A		16							
D3121-144 Bracket Assembly	•	Manufactured	No	892	235	16	Each	5.0000	)	121	).		
and U	~			<b>Location</b>		Loc Qty	<u>L</u>	oc Code					\
<b>3</b> · /				ST235A		5				1110		18	
D3199-1		Manufactured	No	900		2	Each	33.0000		ラダ 無ラ)	( . ·	2.0	
Bracket									9 5	从二分	743	33(	<u> </u>
O 4 1	Ma			Location		Loc Qty	<u>L</u>	oc Code					
Shop L	y			ST236	-10	33			<del></del>				
				786 854		2							(3
	) (			899		30						٠	
D3201-1 3 5200		Manufactured	No	· Inqui			Each	23.0000	1	[4]	20	BE	7378
Doubles Col	ier.			Location		Loc Qty		as Cada	(*************************************		> <del> </del>	1./)	-12
1.40-7				ST033		23	<u>L</u>	oc Code			10		1 T
IN SW	2 US			689		1							
				9 <u>05</u> 924	52	4			-2	*			
				924		7 11							C.
Bracket Assembly	de cue	Manufactured	No			-	Each	0.0000	Commence of the second	[4]	942	4/	52
<b>D4737-044</b>	of the	Manufactured	No				Each	0.0000	1	4_	1 B.	94.	2-9
	<b>,</b> , ,								•	10	7-12	17.	,

											DQ	<b>A</b> : D	ate:	
NCR: Y	'es	/ No					WORK ORDER NON-	COI	VFOR	MANCE / UPDATE				
		·		7							QA Close	d: D	ate:	
Vork Orde	er:						DISPOSITION		AGAINST DEPARTMENT/PROCESS					
Part N	Part No.						Rework Scrap Use-as-is		! Thern	Skid-tube Crosstube Machining Small Fab noforming Finishing	_	Water Je rod. Eng. Coor tore/Packaging	r	Engineering Quality Other
NCR N	10.	÷ .					Work Order Update	ا ل		Large Fab Composite		Supplie	ـــا'	·
Root Cause		Date	Step	Qty	Des		otion of work order update		Initial nief Eng	Action Description	Sign &	Verificati	on	QC Inspector
oc/Data	.′	Date	эсер	Qty			n Non-comormance	10	ilei Liig	Description	Date	Verificati	011	QC IIISPECTOI
quip/Tooling perator flaterial etup ther rocess upplier raining														
	1						F	AUI	T CATE	GORY	<del></del>			1.
Landir	ng G	iear					General			7				
		Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion				Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing		Instruct Mainte Mislabe Misread Offset	ion Incomplete ions Incomplete/Unclear enance eled	Ovalized Over/Under tolerance Part Incorrect Part Lost/Missing Part Moved Positioned Wrong Power Loss/Surge			Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other	
		Turning Sequence Finish							Out of Sequence					

Outside Dimensions

Wave/Twist in Tube

Folio